



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5122-1

Job Sheet 198266



Part No: D5122-1

Job Qty: 10 pcs

Part Name: Center Support, Upper



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/19

Job Tracking No:

Due Date: 8/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEETS 1,2 IPP REV.A NEW ISSUE JFS 14/07/16 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	8/30/19		0.65	18.18	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	10 pcs	8/30/19		0.00	0.00	QC 2 - 1		M.L. 2019/08/13 9:39
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

Plex 7/24/19 9:57 AM Dart.lajeunesse.marie



Container No: S205340



Part: D5122-1

Job No: 198266

Serial No/Batch: S205340

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/13/19

240
A3
240

120	QC 8	10 pcs	8/30/19	0.00	0.00	QC 2 - 66	
						QC 2 - 64	mm 2019/08/13
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	mm 19/08/15
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
QC 8 - 67							
QC 8 - 1 (A)							
QC 8 - 47							
QC 8 - 40							
QC 8 - 52							
QC 8 - 23							
QC 8 - 57							
130	Packaging 3-1 - Stock - B4B	10 pcs	8/30/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	1 A8 19-8-15
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Plex 7/24/19 9:57 AM Dart.lajeunesse.marie	

					Packaging 3 - 28 - B4B			
					Packaging 3 - 29 - B4B			
					Packaging 3 - 30 - B4B			
					Packaging 3 - 31 - B4B			
					Packaging 3 - 32 - B4B			
					Packaging 3 - 33 - B4B			
					Packaging 3 - 34 - B4B			
					Packaging 3 - 35 - B4B			
					Packaging 3 - 36 - B4B			
140	QC 21 - SA	10 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21	DAS AUC 15 2019		
					QC 21 - SA - 70	21		
					QC 21 - SA - 53	9-85		
Part Op 100 - HAAS1-4 (HAAS CNC Vertical Machine) Machine as per Folio FB324 Descriptions: 110 - QC2 Machining-3 (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8 Machining-3 (QC8- Inspect parts - second check) 130 - Packaging3-2 (Identify as per dwg & Stock Location: <u>LG053</u>) LOCATION : LG054 140 - QC21 (QC21- Final Inspection - Work Order Release)								
Job BOM								
Part / Item	Component Name	Quantity	Operation	Container				
D5122-1TRN	Center Support, Upper, Turning Detail	5 pcs (.5 ea)	100-HAAS 4 Axis		S200721 → 1x			
					S110363 → 4x			
Job Allocations								
Operation	Component Part	Required	Inventory	Allocated				
100-HAAS 4 Axis	D5122-1TRN	5	0	0				
Part Specifications								
Specifications could not be found.								

Plex 7/24/19 9:57 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 198266
Description: Center Support		Part Number: D5122-1
Inspection Dwg: D5122	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	1.182	1.202		1.188	1.192	1.190	1.191	1.189
AB	0.090	0.110		.102	.099	.100	.100	.100
AC	0.545	0.565		.549	.553	.550	.550	.547
AD	3.690	3.700		3.697	3.694	3.695	3.696	3.694
AE	3.550	3.560		3.558	3.558	3.556	3.556	3.556
AF	2.453	2.473		2.465	2.466	2.469	2.464	2.465
AG	1.261	1.281		1.275	1.273	1.270	1.269	1.275
AH	0.150	0.210		.190	.195	.190	.190	.200
AI	0.454	0.474		.465	.466	.465	.465	.466
AJ	Ø0.260	Ø0.267		.260φ	.260φ	.260φ	.260φ	.260φ
AK	Ø0.188	Ø0.194		.190φ	.190φ	.190φ	.190φ	.190φ
AL	3.067	3.077		3.072	3.074	3.073	3.073	3.072
AM	3.990	4.010		4.002	4.002	4.000	3.999	3.999
AN	1.990	2.010		1.999	2.001	2.001	2.000	2.000
AO	Ø0.625	Ø0.630		.625φ	.625φ	.625φ	.625φ	.625φ
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to .002 " bore within "								
Accept/Reject				✓				

DAS
64
9-89

Measured by: <i>mtt</i>	Date: 2019/08/09
Audited by: <i>mtt</i>	Date: 19/08/15
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	15.03.12	New Issue	KJ	<i>[Signature]</i>

.861⁵

.641⁵

.313

DART AEROSPACE LTD		Work Order:	198266
Description: Center Support		Part Number:	D5122-1
Inspection Dwg: D5122 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	7	8	9	10
HAAS Section								
AA	1.782	1.202		1.189	1.191	1.192	1.191	1.190
AB	0.090	0.110		.100	.099	.099	.100	.100
AC	0.545	0.565		.551	.549	.550	.551	.550
AD	3.690	3.700		3.695	3.695	3.695	3.694	3.695
AE	3.550	3.560		3.555	3.555	3.555	3.555	3.554
AF	2.453	2.473		2.463	2.466	2.465	2.466	2.467
AG	1.261	1.281		1.269	1.270	1.270	1.269	1.269
AH	0.150	0.210		.198	.198	.200	.195	.200
AI	0.454	0.474		.463	.465	.465	.465	.465
AJ	Ø0.260	Ø0.267		.260p	.260p	.260p	.260p	.260p
AK	Ø0.188	Ø0.194		.190p	.190p	.190p	.190p	.190p
AL	3.067	3.077		3.072	3.074	3.074	3.075	3.073
AM	3.990	4.010		3.999	4.000	3.999	4.000	4.000
AN	1.990	2.010		1.999	1.999	1.999	1.999	1.999
AO	Ø0.625	Ø0.630		.625p	.625p	.625p	.625p	.625p
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject				✓	.003			

Measured by:	M M DAS 64	Date:	2019/08/13
Audited by:	M M C 9-89	Date:	19/08/15
Preliminary Approval:		Date:	

Rev	Date	Change	Revised By	Approved
A	15.03.12	New Issue	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					